

Work Order ID 64130

Thursday, November 25, 2010 10:06:48 AM



Page 1

Item ID: D4278-045

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Rib Assembly, Fwd Cham

Start Date: 11/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-11-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4278	PA1

100 Weld per dwg A/R S.S. rod Batch: 111586 0.00



Large Fab

Memo

0.00

PPL 10.11.25(1x)

Large Fab

1- Assemble ribs and weld as per dwg DT

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Quality Control

PBE
10.11.251 ✓

120 QC5- Inspect part completeness to step on W/O 0.00 - inspect to PA1



QC

Quality Control

Dug only
10.11.25 (x)

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Page 2

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Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: 3KSet Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

STOCK IN BASKET CELL

QA Test Report Rev. A 10/11/25

POSITIVE RECALL

EFFECTIVE 10/11/25 AUTH MFRELEASED 10/11/25 DATE 10/12/03

Picklist Print

Page 1

Thursday, November 25, 2010 10:06:47 AM

Work Order ID: 64130



Parent Item: D4278-045



Parent Item Name: Rib Assembly, Fwd Cham

Start Date: 11/25/2010

Required Date: 11/30/2010

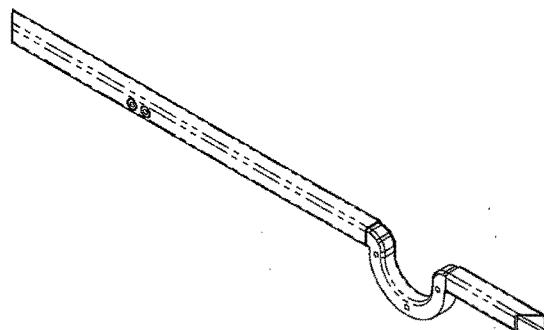
Start Qty: 1.00

Required Qty: 1.00

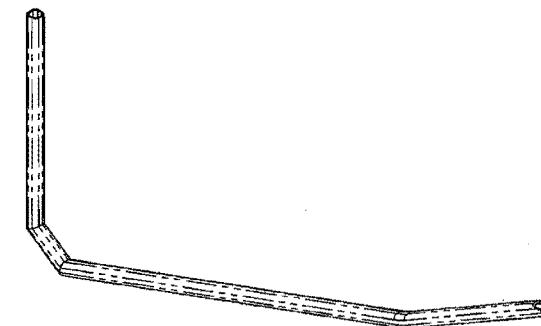
Comments: IPP Rev:A 10.11.12 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4277-11 		Manufactured		No		100	Each	0.0000	1	1		364132	Op 10.11.25
Rib D4277-7 		Manufactured		No		100	Each	0.0000	1	1		364131	Op 10.11.25

8 7 6 5 4 3 2 1



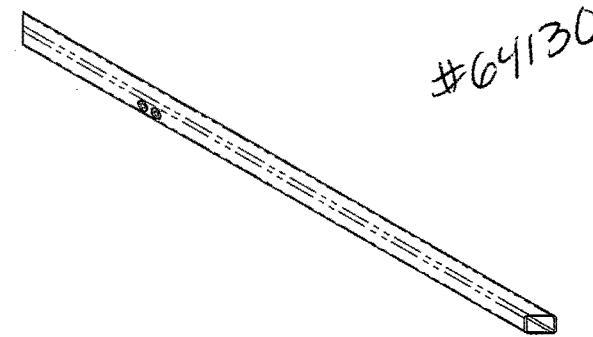
D4278-041 UPPER RIB ASSY-HOOP



D4278-043 RIB ASSY, AFT CHAM



D4278-045 RIB ASSY, FWD CHAM



D4278-047 UPPER RIB ASSY-STRaight

PRELIMINARY ISSUE

Nov. 11, 2010

PA1	PRELIMINARY	JPH	10.11.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PA1
MFG. APPR.	<i>[Signature]</i>	D4278	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSEMBLY	NTS
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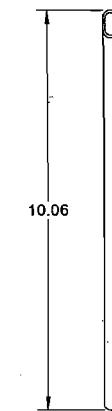
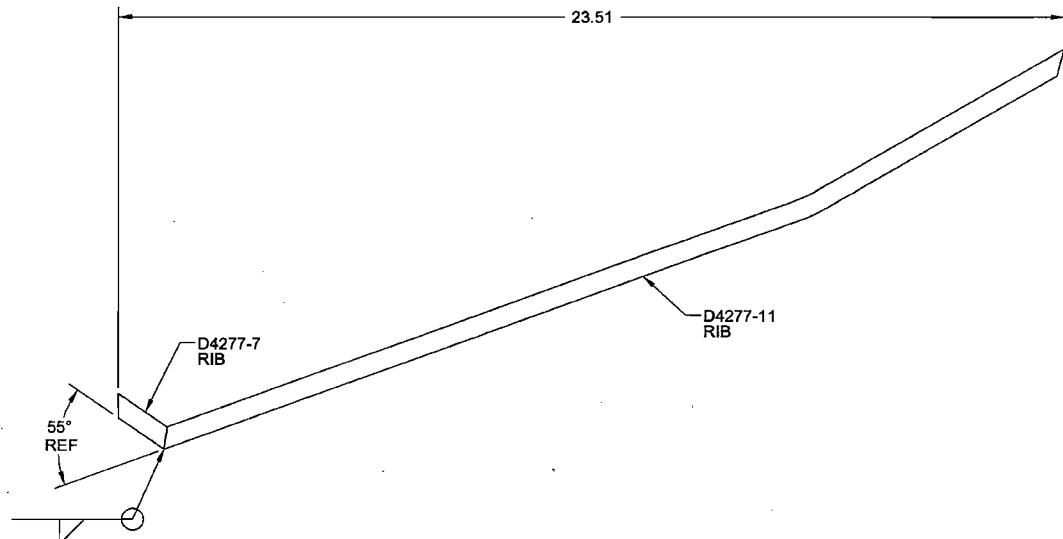
8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

ITEM	QTY	PART NUMBER	DESCRIPTION
	-045		
		D4278-045	RIB ASSY, FWD CHAM
1	1	D4277-7	MID CORNER RIB, NOTCH
2	1	D4277-11	MID DIAG RIB

D

D



D4278-045 RIB ASSY, FWD CHAM

#64130

A

A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.57 lbs
- 8) WELD PER DART QSI 004.

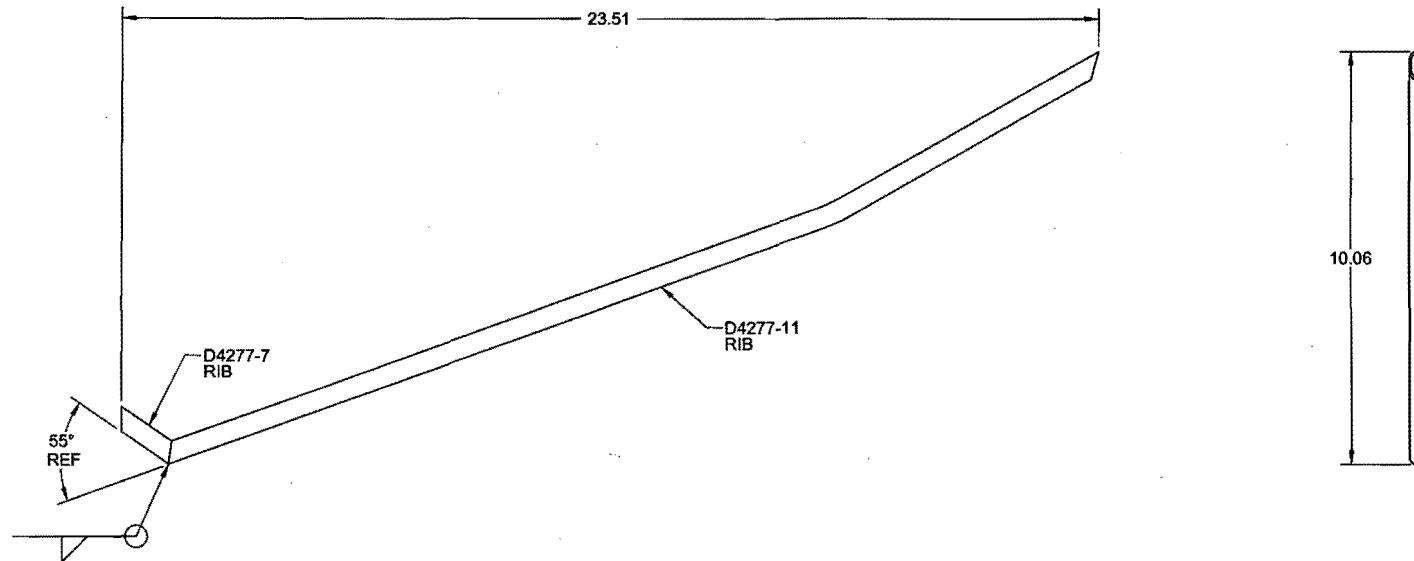
PRELIMINARY ISSUE

NOV 11, 2010

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO.	
MFG. APPR.	<i>JP</i>	REV. PA1	
APPROVED	<i>JP</i>	SHEET 4 OF 5	
DE APPR.		TITLE	
DATE	10.11.11	SCALE	
		RIB ASSEMBLY	
		NTS	
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8 7 6 5 4 3 2 1

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D4278-045 RIB ASSY, FWD CHAM

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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4278	
MFG. APPR.		REV. A	
APPROVED		SHEET 4 OF 5	
DE APPR.		TITLE RIB ASSEMBLY	
DATE 10.11.25		SCALE NTS	

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